

5/03

DART AEROSPACE LTD	Work Order:	22078
Description: Bracket	Part Number:	D3209-041
Dwg: D3209 Rev. A	Qty:	4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JA	04.12.08	4
2	MV	Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) Identify for D3209-1 Batch: <u>M11901</u>	EP	04.12.10	4
3	MV	Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1	mt	04.12.13	4
4	QC2	Inspect parts as they come off the CNC machine	mt	04.12.13	4
5	MV	Deburr and Tumble	mt	04.12.13	4
6	QC8	Second check	E	04.12.13	4
7	FP	Chemical conversion Coat as per QSI 005 4.1	J	04-12-15	4
8	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 Note: Cover the hole for D3209-1 before powder coat.	ML	04.12.20	4
9	QC3	Inspect Powder Coat	Z	05.01.11	4
10	GA	Press fit bushing into the bracket as per Dwg D3209 Pick: Packing Kit Qty Part Number Description Batch 1 D3209-3 Bushing <u>B22081</u>	Z	05.01.11	4
11	QC5	Inspect work to Step 10	TF	05.01.20	4
12	ST	Identify and Stock	CL	05.01.20	4
13	AC	Cost / part: <u>44.84</u>	SAC	05.01.21	4
14	DC	Close W/O <u>55.28</u> Inspect Level 21	JA	05.01.24	4

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	TF

RELEASED

04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022078
Project Name : D3209-041
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3209-041
Description : Bracket
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 12-06-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

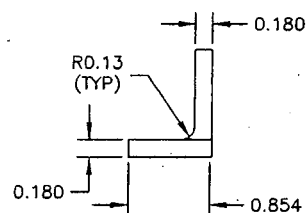
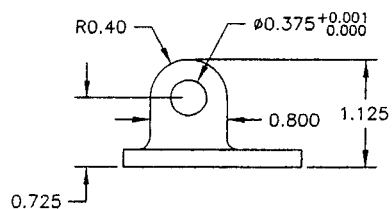
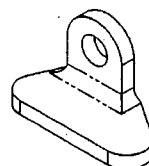
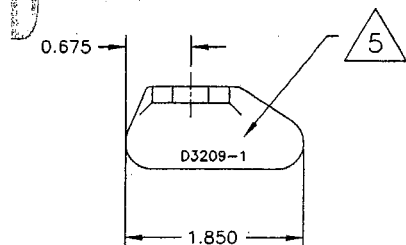
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



CONTROLLED COPY

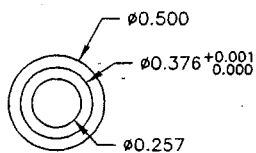
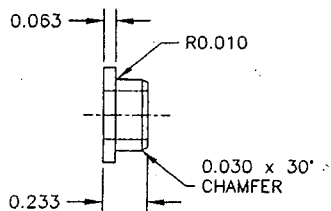
DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 H



2

D3209-1 BRACKET

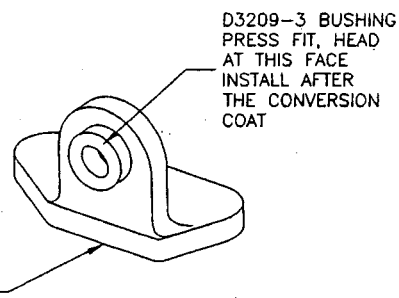


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**D3209-3 BUSHING
SCALE 1:2**

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D3209-041 ASSEMBLY



D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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